

Work Order ID 57958

April 21, 2010 9:18:36 AM



Page 1

Item ID: D3564-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 21/04/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10/4/21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** ☐ Dwg Rev: D ☐ Prog

Rev: D ☐ 2-Deburr if necessary

304 .063

10-4-27

(14)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-4-27

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Solo/27

(14)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Setup Start



Stop



Cust Item ID:

Customer:

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Process Plan:

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

0.00

Memo

Deburr if necessary ☐ Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155 ☐ Form Joggle as per Dwg D3564 on brake using Jig DT 8157

8/10/04/29

(14)

8

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

Ensure joggle as per dwg D3429

8/10/04/29

(44)

150



Large Fab

Large Fab

Large Fab

0.00

0.00

Memo

Qty Description Batch ☐ A/R 2059B Hardcoat
☐ Weld hardcoat as per Dwg D3564

M114460

EL 10-5-3

(14)

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Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8 10/05/03

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8 10/05/03

(X/4)

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M112588

Memo

0.00

7 10/05/04

X4 8

Powder Coating

START TIME:

2:45pm

OVEN TEMPERATURE:

3:15pm FINISH TIME:

320°C

W/O:		WORK ORDER CHANGES					
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Page 4

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Item Name: Wearshoe

Stop



Start Date: 21/04/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7m-1 10/05/05



200

Identify as per dwg & Stock Location: FP-19

0.00



Packaging

Memo

0.00

Packaging

10/05/05

X14 0

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/05

C2 10/5/4

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NOTE: Date & initial all entries

Picklist Print

April 21, 2010 9:18:40 AM

Page 1

Work Order ID: 57958



Parent Item: D3564-9



Parent Item Name: Wearshoe

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M304S16GA	Purchased		No			100	sf	0.0000	17.8105	22.77		
											1810-4-27	

304/316 Sheet .063

(14)

304 . 063

114467

114467

W/O:		WORK ORDER CHANGES					
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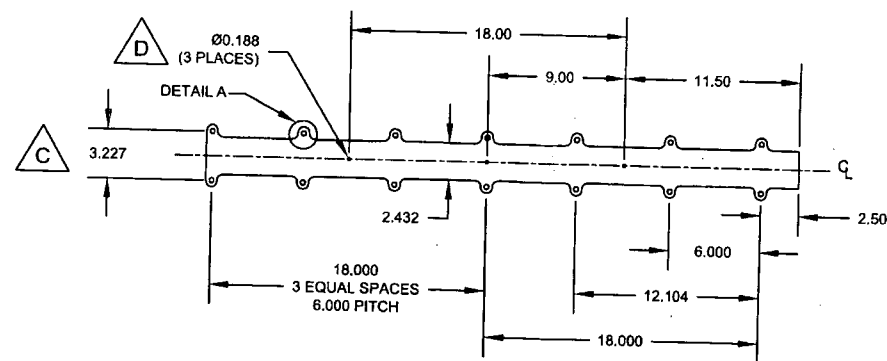
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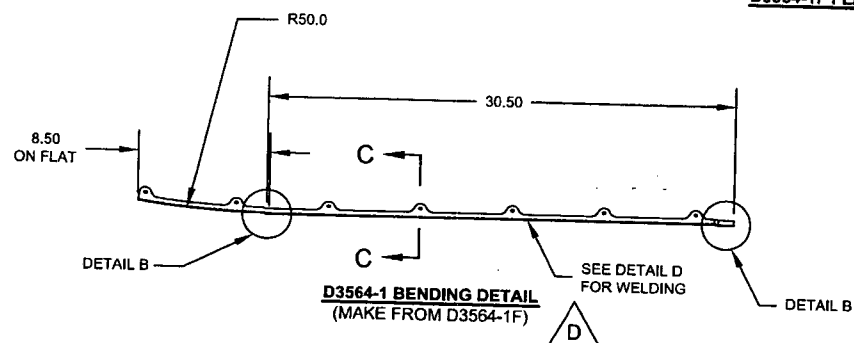
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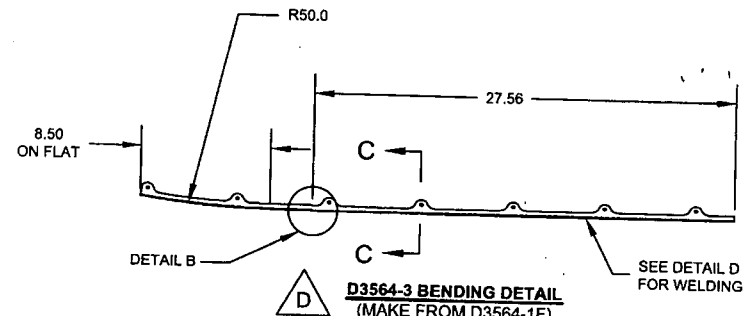
8 7 6 5 4 3 2 1



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57958

BS10-4-21

RELEASED
07.09.04

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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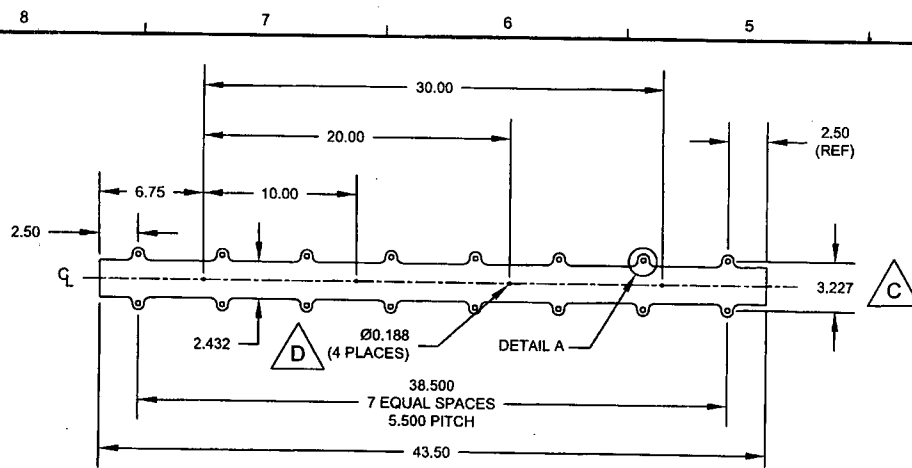
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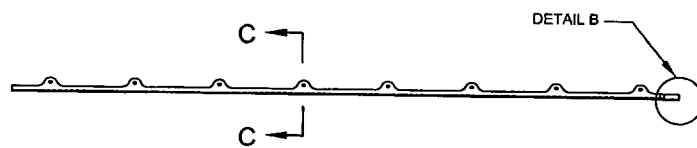
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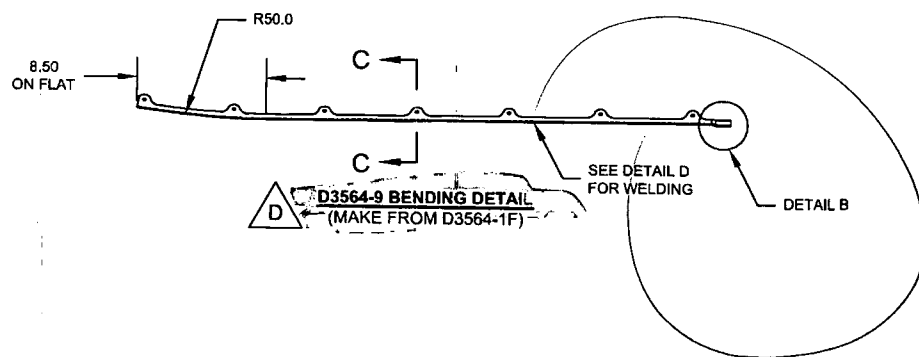
NOTE: Date & initial all entries



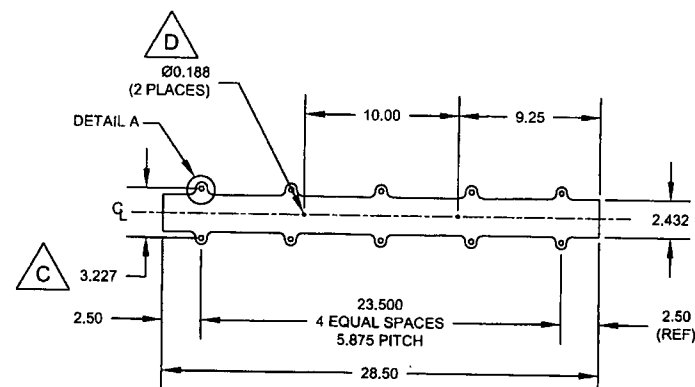
D3564-5F FLAT PATTERN



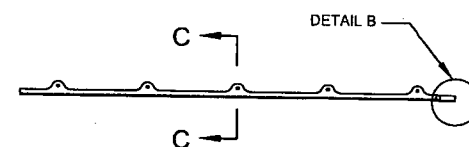
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



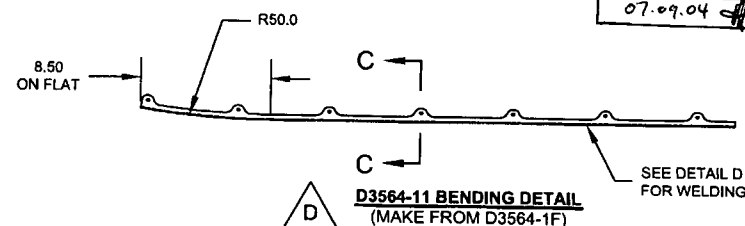
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

W/O 52958

RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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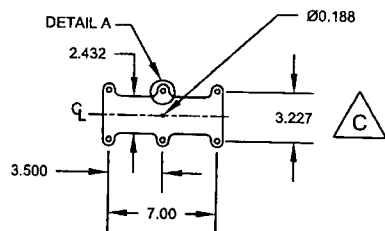
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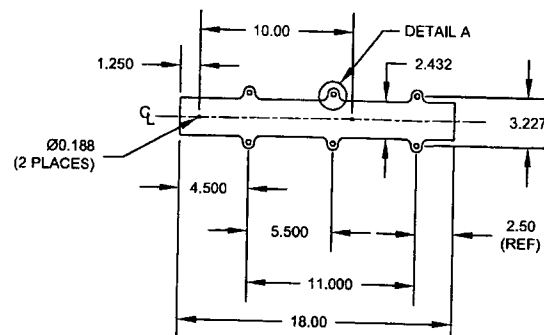
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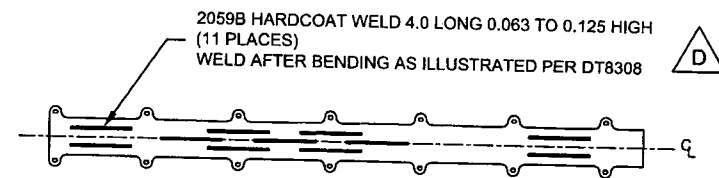
NOTE: Date & initial all entries



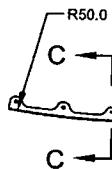
D3564-13F FLAT PATTERN



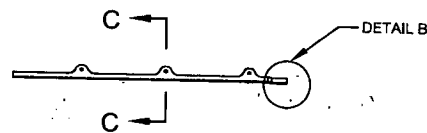
D3564-15F FLAT PATTERN



DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



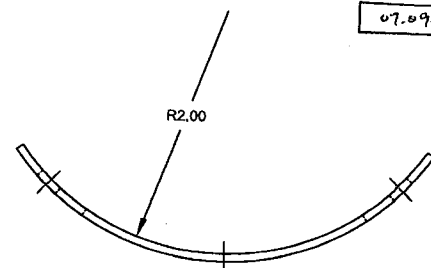
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



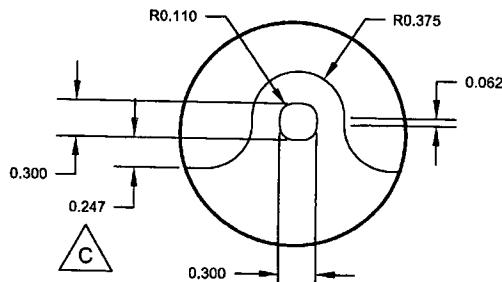
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

RELEASED

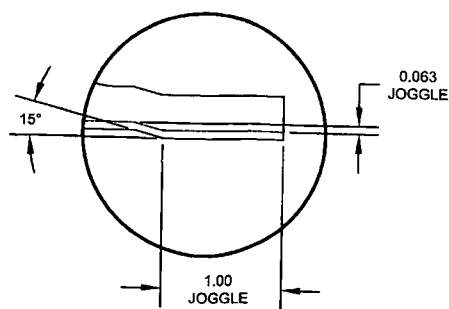
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

w/o 57958

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